

WHAT IS CLAIMED IS:

1. A method of making a biopsy needle comprising the steps of:

providing a proximal needle segment having at least one lumen segment extending therethrough;

forming a distal needle segment about the proximal needle portion, wherein the distal needle segment is formed to have a lumen segment continuous with the lumen segment of the proximal needle portion.

2. The method of Claim 1 wherein the proximal needle segment provides a support structure in the step of forming the distal needle portion.

3. The method of Claim 1 wherein the step of forming the distal needle segment comprises molding the distal needle portion about a portion of the proximal needle portion.

4. The method of Claim 1 wherein the step of forming the distal needle segment comprises injection molding the distal needle portion.

5. The method of Claim 1 wherein the step of forming the distal needle segment comprises forming a tissue receiving port in communication with the lumen segment of the distal needle segment.

6. The method of Claim 1 wherein the step of forming the distal needle segment comprises providing a plurality of passageways extending through an outer surface of the distal needle segment.

7. The method of Claim 1 wherein the step of forming the distal needle segment comprises forming a tissue receiving port and a plurality of fluid passageways extending through an outer surface of the distal needle segment.

8. The method of Claim 1 wherein the step of forming the distal needle segment comprises forming a cutter lumen segment and a vacuum lumen segment.

9. The method of Claim 8 wherein the step of forming the distal needle segment comprises forming a plurality of interlumen vacuum holes between the cutter lumen segment and the vacuum lumen segment.

10. The method of Claim 8 wherein the step of forming the distal needle segment comprises forming a plurality of fluid passages extending from the vacuum lumen segment through an outside surface of the distal needle segment.

11. A method of making a biopsy needle comprising the steps of:

providing a proximal needle segment having at least one lumen segment extending therethrough; and

molding a distal needle segment to be supported on a distal portion of the proximal needle segment, wherein the distal needle segment extends distally from the proximal needle segment, and wherein the distal needle segment is molded to have at least one lumen segment continuous with the lumen of the proximal needle segment.

12. The method of Claim 11 wherein the step of molding the distal needle segment comprises forming two generally parallel lumen segments therein.

13. The method of Claim 11 wherein the step of molding the distal needle segment comprises:

providing a mold having a mold cavity;
positioning a portion of the proximal needle segment to extend into the mold cavity;
positioning at least one mold core through a lumen segment in the proximal needle segment, wherein the mold core extends into the mold cavity from the proximal needle segment;
introducing a flowable non-metallic material into the mold cavity; and

hardening the flowable non-metallic material around the mold core and a distal portion of the proximal needle segment to form a distal needle segment having a lumen segment continuous with the lumen segment of the proximal needle segment.

14. The method of claim 11 further comprising the steps of

providing a piercing tip; and

molding the distal needle segment to capture the piercing tip at a distal end of the distal needle segment.

15. A method of molding a needle comprising the steps of

providing a proximal needle portion having a first lumen segment and a second lumen segment;

positioning a first core to extend through the first lumen of the proximal needle portion;

positioning a second core to extend through the second lumen of the proximal needle portion;

positioning mold portions about the proximal needle portion;

providing a first plurality of support pins for supporting a distal portion of the first core;

providing a second plurality of support pins for supporting a distal portion of the second core;

introducing a flowable material into a cavity formed by the mold portions wherein the flowable material contacts a distal portion of the proximal needle segment, the first core, the second core, and the support pins; and

hardening the flowable material to form a distal needle segment overlapping with and extending from the proximal needle segment, wherein the distal needle segment portion is molded to have a first lumen segment continuous with the first lumen segment of the proximal needle portion and a second lumen segment continuous with the second lumen segment of the proximal needle portion.